

**Work Order ID 105136**

Tuesday, July 23, 2013 1:11:50 PM

**\*105136\***

Page 1

Item ID: D4130-7

Accept

Revision ID:

Item Name: Center Cargo Floor Protector

*3/1MF*

Start Date: 7/23/2013 Start Qty: 1.00

**\*1\***

Required Date: 7/23/2013 Req'd Qty: 1.00

**\*1\***

Reference:

Approvals: Process Plan: *MW*Date: *13.07.23*

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\*****Sequence ID/  
Work Center ID****Operation  
Description****Set Up/  
Run Hours**

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	--------------	---------------	---------------	------------------	----------------

**Draw Nbr****Revision Nbr**

D4130

B

0.00

100

**\*100\***

Waterjet

FLOW WATER JET

**Memo**

0.00

3

0

*Ae  
13.07.24*

FLOW CNC Waterjet

I-Cut as per Dwg  
 Dwg Rev: B  
 Prog Rev: B  
 2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

3

0

*Ae  
13.07.24***\*110\***

QC

Quality Control

**Memo**

0.00

120

QC8- Inspect parts - second check

0.00

*8/28***\*120\***

QC

Quality Control

**Memo**

0.00

*13.7.24*

3

NCR: Yes / No

## **WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: Date:

OA Closed: Date:

Work Order: _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other			
Part No. _____  NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending	Bend	Grain	Ovalized	Pressure/Forced							
Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure							
Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld							
Crushed/Crimped	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled							
Cuffs	Contamination	Maintenance	Part Moved								
Heat Treat	Countersink	Mislabeled	Positioned Wrong								
Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge								
Ripples in Bend	Drill Holes	Offset									
Torque Waves in Extrusion	Drawing	Out of Calibration									
Turning Sequence	Finish	Out of Sequence									
Wave/Twist in Tube	Folio	Outside Dimensions									

**Work Order ID 105136**

Tuesday, July 23, 2013 1:11:50 PM

Item ID: D4130-7

Accept

**\*105136\***

Page 2

Revision ID:

Item Name: Center Cargo Floor Protector

Start Date: 7/23/2013 Start Qty: 1.00

**\*1\*****\*N900040100\***

Setup

Start

**\*NS1\***

Required Date: 7/23/2013 Req'd Qty: 1.00

**\*1\***

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg &amp; Stock Location:

0.00

**\*130\***

Packaging

Packaging

Memo

SYNP  
105134

0.00

13/7/24 (3)

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Quality Control

Memo

0.00

M/C 13-0814

ME 7-27  
13-7-27**POSITIVE RECALL**EFFECTIVE 13-07-13 AUTH by MZL/cert  
RELEASED 5 DATE 13-07-24Material Cert. issued  
13/7/24 S

NCR: Yes / No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____ Part No. _____ NCR No. _____				<b>DISPOSITION</b>		<b>AGAINST DEPARTMENT/PROCESS</b>					
				Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Machining <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	
				Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Finishing <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>	
				Work Order Update <input type="checkbox"/>				Rec/Store/Packaging <input type="checkbox"/>	Supplier <input type="checkbox"/>	Other <input type="checkbox"/>	
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
<b>FAULT CATEGORY</b>											
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube					<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions						
					<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other						

# Picklist Print

Tuesday, July 23, 2013 1:11:50 PM

Page 1

Work Order ID: 105136

Parent Item: D4130-7

Parent Item Name: Center Cargo Floor Protector

Start Date: 7/23/2013

Required Date: 7/23/2013

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.06.08 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04 GE PLASTICS LEXAN SHEET		Purchased	No			100	sf	307.4920	17.674	20,792941	126425	Ae	
													13.07.24
Location				Loc Qty			Loc Code						
MAT018				307.492									
124866				307.492									

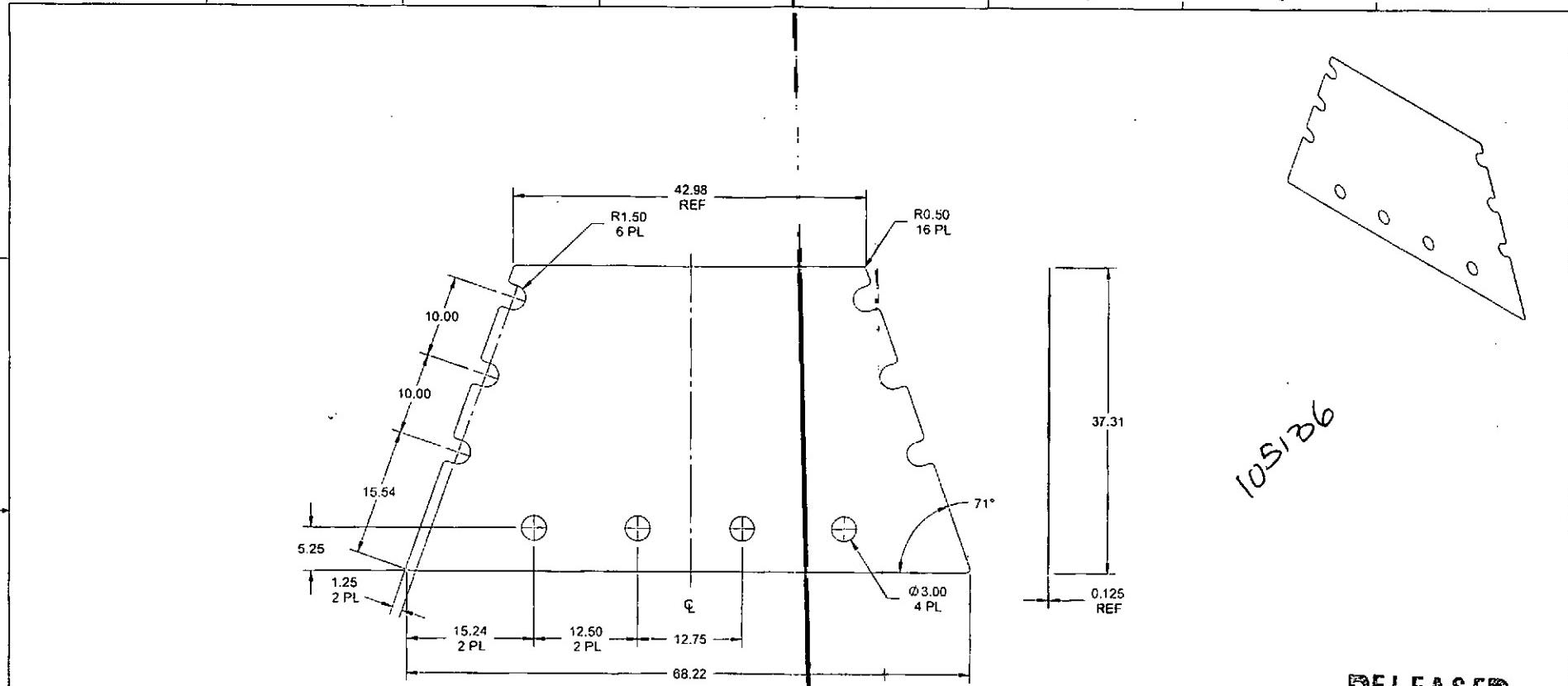
NCR: Yes / No

## **WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: Date:

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS										
				Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>								
				Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>								
				Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>								
				Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>									
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector						
Doc/Data																
Equip/Tooling																
Operator																
Material																
Setup																
Other																
Process																
Supplier																
Training																
Unapproved																
FAULT CATEGORY																
Landing Gear				General												
Bending	<input type="checkbox"/>			Bend	<input type="checkbox"/>			Grain	<input type="checkbox"/>			Ovalized	<input type="checkbox"/>			Pressure/Forced
Centre Not Concentric to O/S	<input type="checkbox"/>			BOM/Route	<input type="checkbox"/>			Hardware	<input type="checkbox"/>			Over/Under tolerance	<input type="checkbox"/>			Temperature/Cure
Cracks	<input type="checkbox"/>			Broken/Damaged	<input type="checkbox"/>			Inspection Incomplete	<input type="checkbox"/>			Part Incorrect	<input type="checkbox"/>			Weld
Crushed/Crimped	<input type="checkbox"/>			Burrs	<input type="checkbox"/>			Instructions Incomplete/Unclear	<input type="checkbox"/>			Part Lost/Missing	<input type="checkbox"/>			Wrong Stock Pulled
Cuffs	<input type="checkbox"/>			Contamination	<input type="checkbox"/>			Maintenance	<input type="checkbox"/>			Part Moved	<input type="checkbox"/>			
Heat Treat	<input type="checkbox"/>			Countersink	<input type="checkbox"/>			Mislabeled	<input type="checkbox"/>			Positioned Wrong	<input type="checkbox"/>			
Inspection Strip in Tube	<input type="checkbox"/>			Cut Too Short	<input type="checkbox"/>			Misread	<input type="checkbox"/>			Power Loss/Surge	<input type="checkbox"/>			
Ripples in Bend	<input type="checkbox"/>			Drill Holes	<input type="checkbox"/>			Offset	<input type="checkbox"/>			<input type="checkbox"/>	<input type="checkbox"/>			Other
Torque Waves in Extrusion	<input type="checkbox"/>			Drawing	<input type="checkbox"/>			Out of Calibration	<input type="checkbox"/>				<input type="checkbox"/>			
Turning Sequence	<input type="checkbox"/>			Finish	<input type="checkbox"/>			Out of Sequence	<input type="checkbox"/>				<input type="checkbox"/>			
Wave/Twist in Tube	<input type="checkbox"/>			Folio	<input type="checkbox"/>			Outside Dimensions	<input type="checkbox"/>				<input type="checkbox"/>			



**D4130-7 CENTER CARGO FLOOR PROTECTOR**  
(TEXTURED SIDE SHOWN)

NOTES:

- 1) MATERIAL: F60029-GY3778 DARK GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK  
REF DART SPEC MLEXS.125-F60029-04
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1 ON SMOOTH SIDE
- 7) WEIGHT: 10.92 lbs

DESIGN	HS	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	KENT, WA	
CHECKED	10	DRAWING NO.	
MFG. APPR.	10	REV. B	
APPROVED	10	D4130	
DE APPR.	10	SHEET 4 OF 5	
DATE 11.07.27		TITLE	SCALE
		FLOOR PROTECTOR	
NTS			

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**RELEASED**  
2011-09-21  
N/A

NCR: Yes / No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Finishing <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
	Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Supplier <input type="checkbox"/>	Other <input type="checkbox"/>				
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data										
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										
FAULT CATEGORY										
Landing Gear	General									
	Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Grain <input type="checkbox"/>	Ovalized <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>					
	Centre Not Concentric to O/S <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Hardware <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>					
	Cracks <input type="checkbox"/>	Broken/Damaged <input type="checkbox"/>	Inspection Incomplete <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Weld <input type="checkbox"/>					
	Crushed/Crimped <input type="checkbox"/>	Burrs <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>					
	Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Maintenance <input type="checkbox"/>	Part Moved <input type="checkbox"/>						
	Heat Treat <input type="checkbox"/>	Countersink <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>						
	Inspection Strip in Tube <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Misread <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	Other <input type="checkbox"/>					
	Ripples in Bend <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Offset <input type="checkbox"/>							
	Torque Waves in Extrusion <input type="checkbox"/>	Drawing <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>							
	Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>							
	Wave/Twist in Tube <input type="checkbox"/>	Folio <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>							

DART AEROSPACE LTD	Work Order:	105136
Description: Center Cargo Floor Protector	Part Number:	D4130-7
Inspection Dwg: D4130	Rev: B	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

27

27

Measured by:	<i>Ak</i>	Audited by:	<i>SG</i>	Preliminary Approval:	
Date:	<i>13.07.24</i>	Date:	<i>13.7.24</i>	Date:	

Rev	Date	Change	Revised by	Approved
A	10.10.25	New Issue	KJ	
B	12.05.15	Dwg Rev updated	KJ	

NCR: Yes / No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order:			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Use-as-is <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>		
Part No. _____			Machining <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
NCR No. _____			Work Order Update <input type="checkbox"/>	Finishing <input type="checkbox"/>	Composite <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Supplier <input type="checkbox"/>	Other <input type="checkbox"/>			
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio		<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other	

## Receiving Report

Date: 13/7/23

Supplier: SABIC

Packing Slip: Yes  No   
 Invoice: Yes  No   
 Receipt: Cash  Cr

Batch No: M126420

Dart P/O: 20296

Release Note Attached: Yes  No  N/A   
 Waybill Attached: Yes  No  N/A   
 Shipment Complete: Yes  No  N/A   
 QC6 Inspection:  N/A   
 Work Order: 51307124  N/A

### Discrepancies

Part Number	Description	Quantity ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12 J

Production/Admin: 13/7/23  
 Date 13/7/23  
 Received/Costing Initial J

Location





Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## **PURCHASE ORDER**

**Purchase Order ID PO20296**

**Purchase Order Date** 6/24/2013  
**PO Print Date** 6/24/2013

Page Number 1 of 1

**Order From :** VC-GEP001  
**SABIC POLYMERSHAPES**  
**1290 OLD INNES ROAD**  
**UNIT 713**  
**OTTAWA, ON K1B 5M6**  
**CA**

**Ship To : DART AEROSPACE LTD  
1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA**

~~FAXED  
C:\B\ocaf.s~~

**Contact Name**

**Buyer** Chantal Lavoie

**Ship To Contact**  
**Ship To Phone**  
**Ship Via:** TST ground  
**Ship A/cats:**

<b>Buyer</b>	Chantal Lavoie
<b>Customer POID</b>	
<b>Customer Tax #</b>	10127-2607
<b>Terms</b>	Net 30
<b>Currency</b>	CAD
<b>FOB</b>	Destination

1. MLEXS.125-F60029-04 GE PLASTICS LEXAN - 7/25/2013 - 2,560.00 / \$15,995.20  
SHEET

MATERIAL: GE PLEXIGLASS LEXAN™ SHEET, COLOR  
CODE:04 GY3778 DARK GREY, TEXTURE F60029 HEAVY  
HAIRCELL/COBB

7/25/2013 - - - 2,560.00

Yes

sf

**Line Total:**

**\$15,995.20**

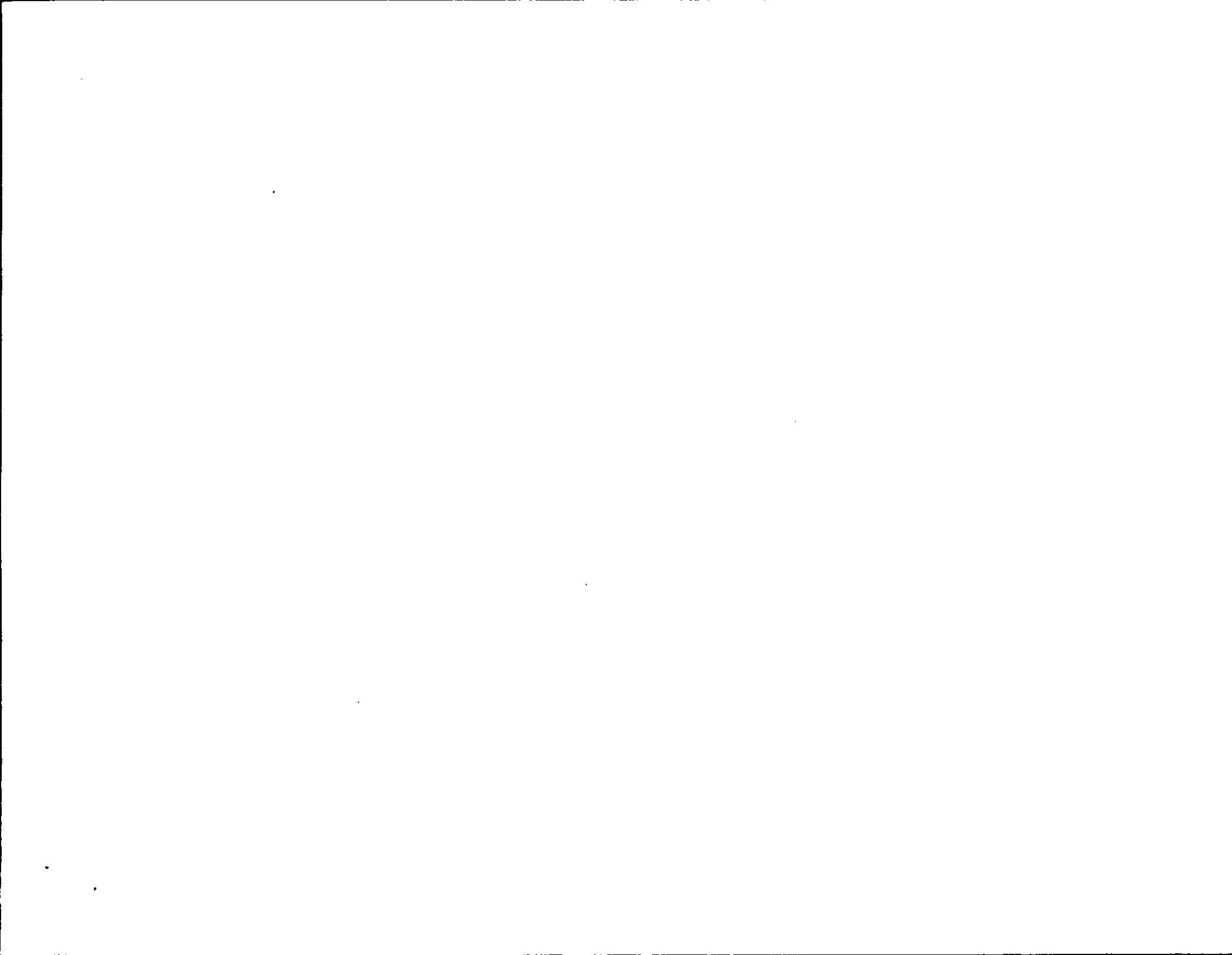
PO Total:

**\$15,995.20**

**Note:** Pricing listed above is as per contract agreement between Dart Aerospace and the respective manufacturer.  
No substitution or deviation without consent.

Certificate of Conformity or Material Certification required  YES  NO

**Change Nbr:** 1                    **Change Date:** 6/24/2013



SABIC  
Innovative  
Plastics

سابك  
sabic

1250 OLD INNES RD. 519 OTTAWA, ONT. K1B 5L3  
TEL: 613 745 7043 FAX: 613 745 4291

**SABIC Polymershapes**

## CERTIFICATE OF COMPLIANCE

SOLD TO: DART AEROSPACE LTD.

DATE: 7/24/2013

YOUR PURCHASE ORDER 20296

OUR SHIPPER NO: 99000774

LINE ITEM #: 1.1

8362124

QUANTITY: 80

DESCRIPTION: LEXAN F60029 GY3778 GREY - 26122 - .125 X 48 X 96

THESE PARTS WERE MANUFACTURED IN ACCORDANCE WITH:

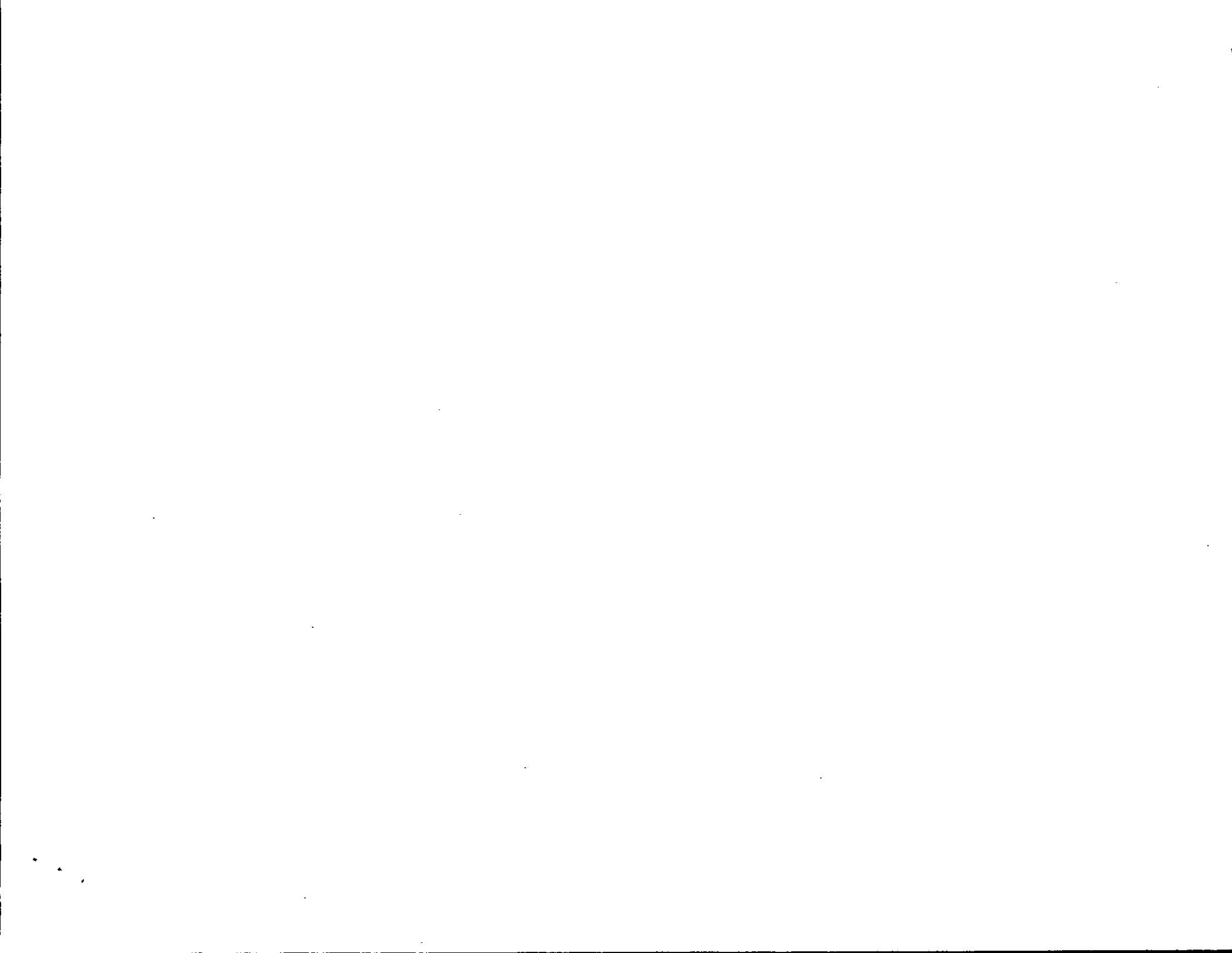
THE ABOVE LEXAN F60029 SHEETS ON THE ABOVE NOTED C OF C WERE  
MANUFACTURED IN ACCORDANCE WITH THE TEST METHODS ON THE ATTACHED  
PRODUCT DATA SHEET.

THIS IS TO CERTIFY THAT THE MATERIAL FINISHES AND FUNCTIONAL REQUIREMENTS  
OF THE ABOVE LISTED PARTS ARE IN ACCORDANCE WITH THE REFERENCE  
PROCUREMENT SPECIFICATIONS, CONTROL DRAWINGS OR PARTS DESIGNATION AND  
LATEST REVISIONS AS REFERENCED ON THE SUBJECT PURCHASE ORDER.

AUTHORIZED REPRESENTATIVE SIGNATURE



MICHAEL POAPS  
OUTSIDE SALES REPRESENTATIVE



Attn: Brigitte C613 632 1053

SABIC  
Innovative  
Plastics™



## Lexan® F6000 Sheet

## Product Datasheet

### Description

Lexan® F6000 sheet is a flame retardant opaque polycarbonate sheet range available in standard and custom colors. In addition to good flammability performance, it offers excellent impact resistance, good stiffness and strength and ease of processing, making it suitable for a wide variety of applications in industries such as electrical/electronics and transportation (e.g. aircraft, rail).

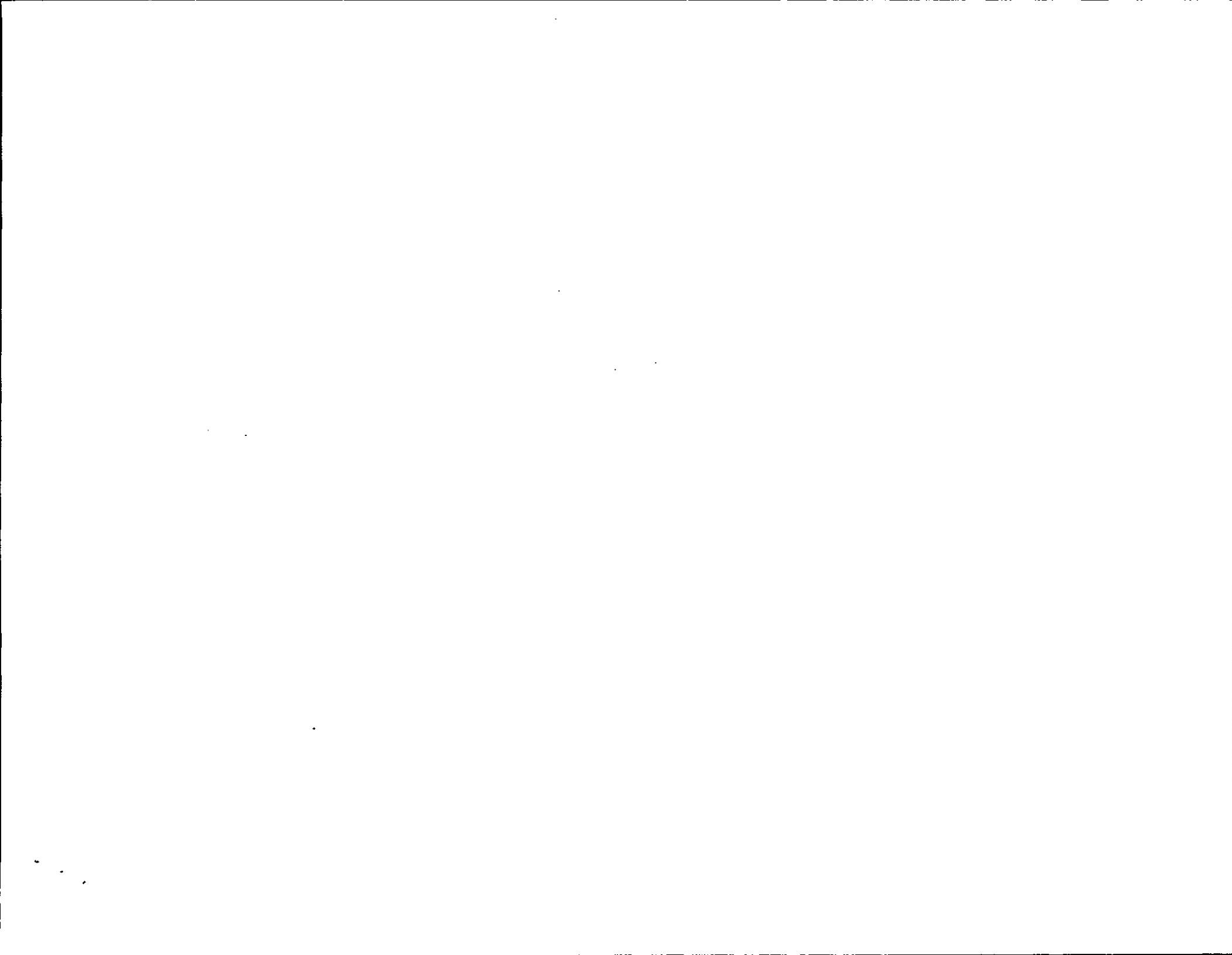
### Typical Property Values

Property	Test Method	Unit	Value
<b>Physical</b>			
Specific Gravity	DIN 53479	-	1.21
Water Absorption, 24hrs equilibrium	ASTM D570	%	0.15
		%	0.35
<b>Mechanical</b>			
Tensile Strength, yield	DIN 53455	MPa	62
Tensile Modulus	DIN 53457	MPa	2200
Elongation, Yield Break	DIN 53455	%	7
		%	95
Flexural Strength, Yield	DIN 53452	MPa	90
Flexural Modulus	DIN 53457	MPa	2240
Izod Notched Impact, 20°C	ASTM D256	J/m	640
		J/m	100
Gardner Impact, 20°C 40°C	SABIC Method	J	>40
		J	>40
Taber Abrasion, CS17, 1000g, 1000cycles	ASTM D1044	mg	10
<b>Thermal</b>			
Vicat Softening Temperature, Rate B/120 DTUL, 1.82 MPa	DIN53460 DIN53461	°C	145 132
Thermal Conductivity	ASTM C177	°C	0.2W/m
Ball Pressure Test 75°C	IEC 335-1		Pass
Ball Pressure Test 125°C	IEC 335-1		Pass
Mold Shrinkage	ASTM D1299	%	0.5 - 1.0
Thermal Expansion	VDE 0304/1	°C	6.8x10 <sup>-5</sup> m/m
<b>Electrical</b>			
Hot Wire Ignition	UL 746A	sec	37
High Voltage Arc Tracking Rate	UL 746A	mm/s	6.2
High Ampere Arc Ign. Surface	UL 746A		20
Comparative Tracking Index	IEC 112/3	V	225.0
Comparative Tracking Index, M	IEC 112/3	V	125.0
Volume Resistivity	ASTM D257	Ohm.m	1015
Surface Resistivity	IEC 93	Ohm.m	1014
<b>Flammability</b>			
Oxygen Index	ASTM D2863	%	35
UL Flammability	UL94	mm	V0 (1.47)
Glow Wire Test, 960 °C	IEC 695-2-1	mm	Pass (2.0)
NBS Smoke, flaming mode, DS, 1.5min DS, 4.0min	ASTM E662		<50 <100
FAA Flammability	FAR 25.853 (a), I, (I) &(II)&(IV)	mm	Pass (1-6)
ABD0031	AITM 3.0005	mm	Pass
BS476, part 7 (1987)		mm	Class (1.5)
CSE RF2/75/A; RF3/77 (ceiling)		mm	Class 1 (1.5, 3)

\* These property values have been derived from Lexan® resin data for the material used to produce this sheet product.

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Lexan®



SABIC  
Innovative  
Plastics™



## Lexan® F6000 Sheet

## Product Datasheet

### Processing

Lexan F6000 sheet is ideally suited to thermoforming. It offers high, deep draw ratios, equal wall thickness distribution, and it can be formed into complex shapes using standard thermoforming equipment. Sandwich type heating systems give the best results. Lexan F6000 sheet has a forming temperature range of 185 - 205°C. When forming, a draft angle of at least 3° should be allowed, and post mold shrinkage of 0.5 - 1.0% taken into account.

### Pre-drying

It is important to ensure that Lexan F6000 sheets are free of moisture prior to thermoforming. A hot air circulating oven set at 120°C is recommended. Pre-drying times vary from 3-12 hours for 1.2 to 4.0mm thick sheets.

### Assembling

Parts made from Lexan F6000 sheet can be assembled with plastics, metals, rubber and other materials using many types of adhesive bonding, welding and mechanical fastening techniques. Since some of these materials can cause environmental stress cracking, please consult SABIC Innovative Plastics, Film & Sheet representative for advice on specific applications.

### Painting

Lexan F6000 sheet is ideally suited for use with a wide variety of modern decoration techniques. A list of approved paint systems and suppliers is available upon request.

### Chemical resistance

Lexan F6000 sheet has sufficient resistance to most mineral oils, greases, aliphatic hydrocarbons and acids under low or moderate stress levels. In applications where the Lexan F6000 sheet will come into contact with aggressive chemicals, specific (application related) testing is always advised. Effective painting systems can improve chemical resistance.

### Product Availability

Product code: Lexan F6000

Textures: Polished/Suede (F6006), Polished/Haircell (F60011N)

See product availability guide for available gauges, sizes, and colors

**Lexan®** Tough  
Virtually  
Unbreakable

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#### Americas:

SABIC Innovative Plastics  
Specialty Film & Sheet  
One Plastics Avenue  
Pittsfield, MA 01201  
USA  
Tel. (1) (413) 448 5400  
Fax. (1) (413) 448 7506  
Toll free: 1-800 451 3147

#### Europe:

SABIC Innovative Plastics  
Specialty Film & Sheet  
Plasticslaan 1  
NL - 4612 PX Bergen op Zoom  
The Netherlands  
Tel. (31) (164) 292911  
Fax. (31) (164) 293272

#### Pacific:

SABIC Innovative Plastics  
Specialty Film & Sheet  
1266 Nanjin Road (W)  
Plaza 66, 17th Floor  
200040 Shanghai, China  
Tel. (86) 21 62881088  
Fax. (86) 21 62880818

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Latest Update SABIC (01/2008)



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INDICATE CLASSIFICATION NMFC/UFC

NMFC: 156300/2

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ALL BEFORE DELIVERY 613-226-748		K6A 1K7	
		613-632-5200	
ART# 41204160			
O# & PART# ON ALL PAPERWORK			
LEASE SHIP THIS MATERIAL TO:			

SHIP TO

REQ. NO./ITEM NO.	THM. PALLETS	WEIGHT PER PKG.	TOTAL UNITS	TOTAL NET WEIGHT	UM	LOT NO.	MKT. GRADE	COLOR	PID	CTR	GAUGE	WIDTH	LENGTH
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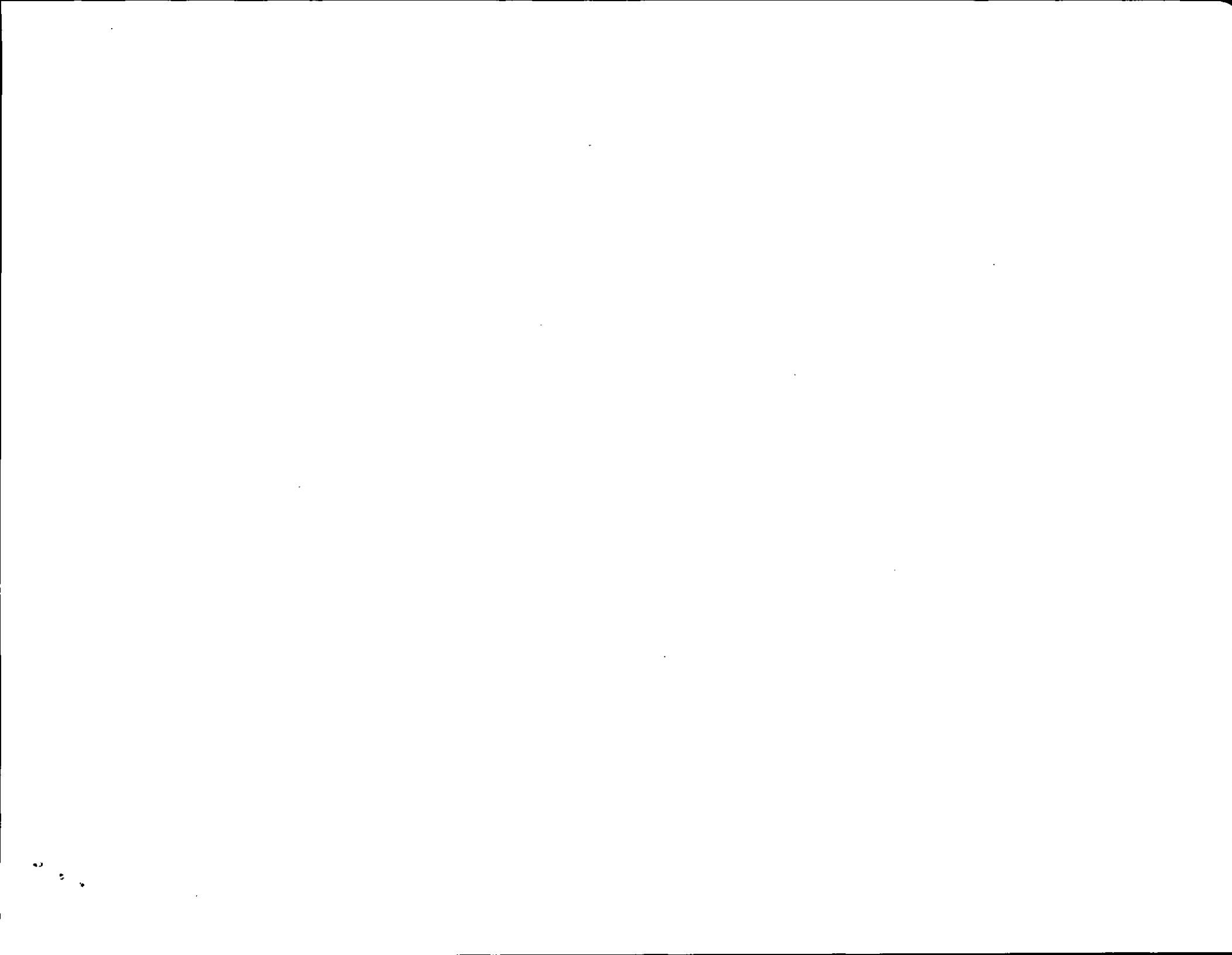
THIS MATERIAL WAS PRODUCED IN CANADA

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REF PART

For Chemical Emergency - Spill, Leak, Fire, Exposure or Accident - Call Chemtrec - Day or Night (800) 424-9300 (Toll Free)

PRODUCT WEIGHT	PRODUCT/PACKAGE WEIGHT	NO. OF PALLETS	TOTAL GROSS WEIGHT	CARRIER
2022.000	917.17 KG	100	2432 LBS	KG
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TRANSFERRED TO / TRANSFÉRÉ À				1314 July 23/13	
				TIME IN / TEMPS ENTRÉ	TIME OUT / TEMPS SORTIE

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